

Date: Thursday, 7/13/2006 9:30:21 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SKIDTUBE ASSEMBLY RH
Job Number	: 27732		
Estimate Number	: 10265		
P.O. Number	: N/A	Part Number	: D350636012
This Issue	: 7/13/2006	S.O. No. :	N/A
Prsht Rev.	: NC	Drawing Number	: D2750 REV D
First Issue	: 6/28/2006	Project Number	: N/A
Previous Run	: 27731	Drawing Revision	: D
		Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 7/30/2006
Checked & Approved By	: <u>[Signature]</u> 06-07-13	Qty:	1 Um: Each
Comment	: Est Rev: I 02-09-25 Rearranged procedure steps KJ Est Rev: J 06-03-29 As per Rev D EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 002

KS 06-07-17 (1)

2.0	D26003BENT	Extrusion Bent
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2600-3-Bent	Extrusion (Bent)	B26787

Pm 06-07-240

3.0	D2744	Fwd Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch: 225839 BE 06-07-250

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

Pm 06-07-240

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8863 drilling holes labelled "A" only.

Pm 06-07-240

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

Pm 06-07-240

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/13/2006 9:30:21 AM
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Seq. #:

Machine Or Operation:

Description :

4-Drill pilot holes for Detail B using DT8330

5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" ***Make sure that wearplate holes are on bottom of tube*****

6-Open up holes of Detail A to 0.250" (total of 2 holes per side)

7- Countersink all fwd wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750.

8-Countersink Detail A as per dwg D2750.

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *M100660 BE 06-07-25*

10-Grind welds flush as per Dwg D2750 *BE 06-07-27*

5.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

BE 06-08-01

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pm 06-08-01

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-08-01

8.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch: *B27503*

Pm 06-08-01

9.0

D34901

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: *B27385 BE 06-08-09*

W/O:		WORK ORDER CHANGES					
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY-RH

Job Number: 27732

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D34903

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: 227973 BE 06-08-09

11.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch: 226208 BE 06-08-09

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750.

2-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side) as per dwg D2750.

3-Open up holes of Detail D to 0.750" (total of 4 holes per side) as per dwg D2750.

4-Chamfer holes of Detail V, Detail C, Detail D and hole size "W" per dwg D2750 (welding instructions on sheet 4)

5-Deburr and blow out all chips from inside of tube

6-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch: m101621

exp. date: 07-2001

Pm' 06-08-01

7- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 4)

A/R

Aluminum Rod

batch: m100660 BE 06-08-09

60

8-Grind welds flush as per Dwg D2750 Pm' 06-08-10

9-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750 Pm' 06-08-10

10-Deburr holes Pm' 06-08-10

W/O:		WORK ORDER CHANGES					
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Job Number: 27732

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 20

QC5-DP 06-8-11 / QC9-M 06/08/11 (1)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

FC 06 08 21 (1)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

a.m 06-08-21 (1)

16.0

ALS41032225

Insert



Comments: Qty.: 46.0000 Each(s)/Unit Total: 46.0000 Each(s)

Insert

Batch: _____

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

a.m 06-08-22 (1)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

06-08-22

19.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Wearpad

Batch: 327169-2

20.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: 327074

a.m 06-08-22 (1)

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Job Number: 27732

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B27258

22.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B27485

23.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: D26140

24.0

D3488042

BLADE FITTING ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: D26839

25.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B27191

26.0

D3492043

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B27519

a.m 06-04-22

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 27732

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

~~AN835A~~

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bolt

Batch: _____

28.0

~~AN960JD846~~

1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: _____

29.0

~~MS21083N8~~

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Nut

Batch: _____

30.0

~~AN960JD10L~~

Washer



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

washer

Batch: _____

31.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Bolt

Batch: M161620

32.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: 3019 B19522

33.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: B101124

a.m

06-08-22

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 27732

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: B19514

35.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: OK B101261

36.0

AN960C10L

washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

washer

Batch: B100186

37.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: m100186

38.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: m19185

39.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: m100186

40.0

NAS1330S3KB166

INSERT



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

INSERT

Batch: M101451

a.m 06-08-22

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
		27643						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/13/2006 9:30:22 A
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 27732

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

NAS1515H3L

WASHER



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

WASHER

Batch: m 19099

42.0

NAS1515H8L

WASHER



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

WASHER

Batch: m 100187

43.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DL

04/08/24

(1)

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects FC

2-Spray inside of tube with "LPS-3" FC

batch: m 101092

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: m 101855

EXP DATE: 02 07

4-Coat all exposed fasteners with "LPS Procyon"

batch: m 17168

FC

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

46.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 27186 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/13/2006 9:30:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 27732

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M/00186 ✓

48.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M/00186 ✓

49.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M/00262 ✓

50.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M/00187 ✓

51.0

D34931

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

B27895 ✓

52.0

D35321

spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

spacer

Batch: B27894 ✓

PU 6/1/25 (1)

53.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SL 06/02/25 (1)

W/O:		WORK ORDER CHANGES					
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 04/06/20

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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User: Kim Johnston

Process Sheet

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 27732

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

Rev. E

06/08/25

55.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/28

Job Completion



06-08-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART**RELEASED**
06-02-07

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. D SHEET 1 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133/9157	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
5	5	5	5	D2648-3	WEARPAD
1	1	1	1	D2656-13	WEARSHOE
1	1	1	1	D2656-35	WEARSHOE
1	1	1	1	D2746	WEARSHOE
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
2	2	2	2	AN8C21A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
4	4	4	4	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
3	3	3	3	MS21083C8	NUT
42	42	42	42	NAS1330S3KB166	INSERT
46	46	46	46	NAS1515H3L	WASHER
12	12	12	12	NAS1515H8L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27732

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DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D2750	REV. D SHEET 2 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

RELEASED
06.02.07

GENERAL NOTES:

1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES ($\emptyset 0.250$ - $\emptyset 0.257$) FOR WEARSHOE INSERTS. C'SINK $\emptyset 0.391 \times 100^\circ$ AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

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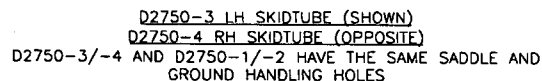
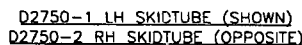
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DATE 06.01.05	

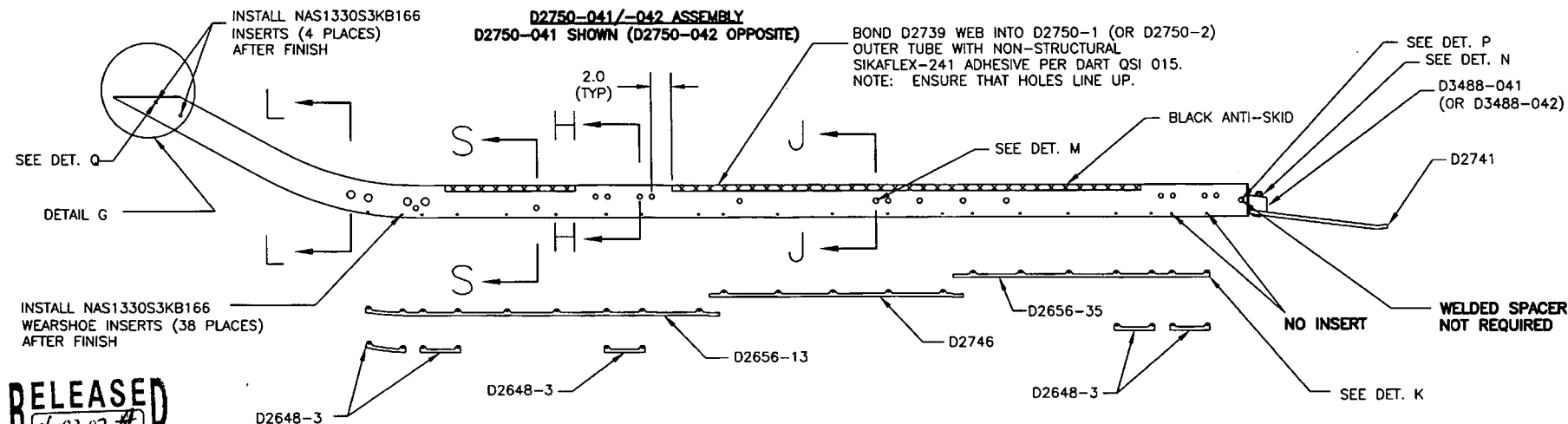
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TITLE 350 SKIDTUBE ASSEMBLY		SCALE 1:20	

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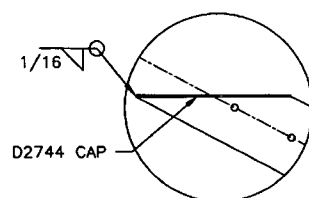
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06.02.07 #

D2750-041/-042 ASSEMBLY
D2750-041 SHOWN (D2750-042 OPPOSITE)

BOND D2739 WEB INTO D2750-1 (OR D2750-2)
OUTER TUBE WITH NON-STRUCTURAL
SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.



DETAIL G



SECTION H-H



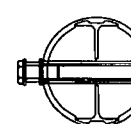
SECTION J-J



WELDING INSTRUCTIONS

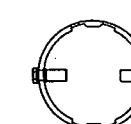
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

DETAIL M



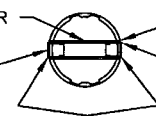
- AN6-44A BOLT (1)
D2745 BUSHING (2)
NAS1515H8L WASHER (2)
MS21043-6 NUT (1)
(4 PLACES)
NOTE: INSTALL WASHER BETWEEN SKIDTUBE AND BUSHING

DETAIL Q



- AN3C6A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(4 PLACES)

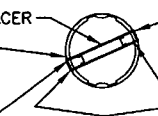
SECTION L-L



Ø0.750 HOLES ONLY

D3492-043 PLUG ASSEMBLY

SECTION S-S



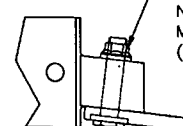
Ø0.500 HOLES ONLY

D3492-041 PLUG ASSEMBLY

WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO Ø0.750 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS

DETAIL N



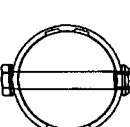
- AN8C21A BOLT (1)
AN960JDB16L WASHER (1)
NAS1515H8L WASHER (1)
MS21083C8 NUT (1)
(2 PLACES)

DETAIL K



USE AN3C7A BOLTS
FOR INSTALLING AFT
D2648-3 WEARPAD
(4 PLACES)

DETAIL P



- AN3C5A BOLT (1)
AN960JDB10L WASHER (1)
NAS1515H3L WASHER (1)
(38 PLACES)
AN8C35A BOLT (1)
AN960C816L WASHER (2)
NAS1515H8L WASHER (2)
MS21083C8 NUT (1)

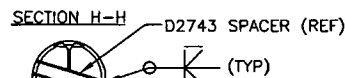
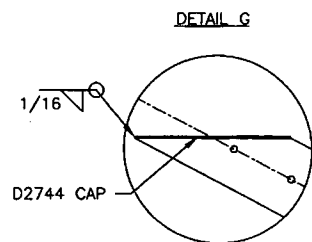
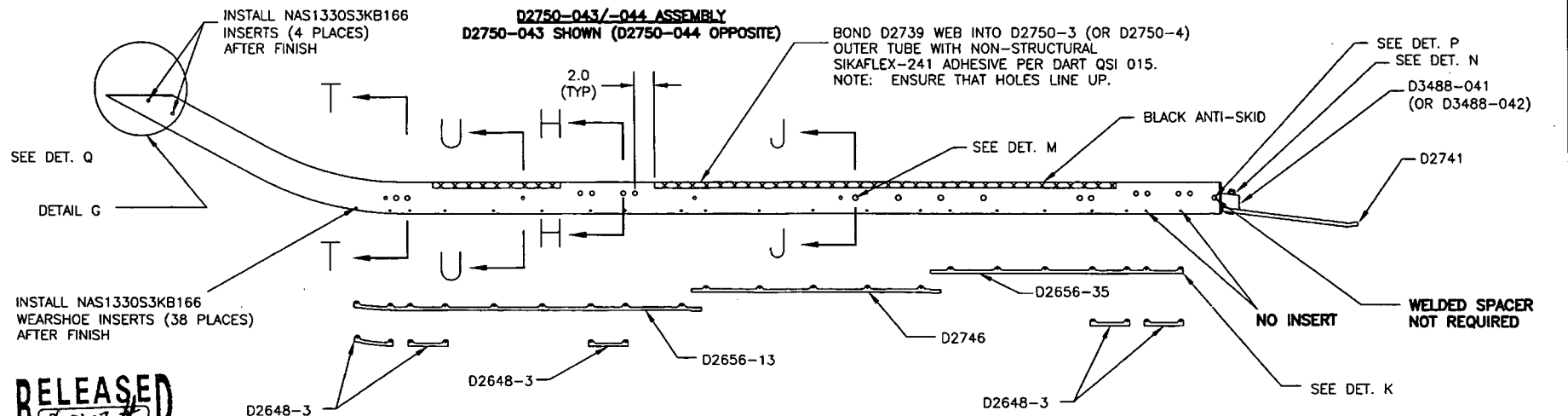
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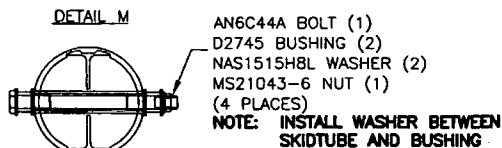
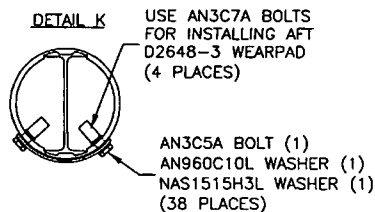
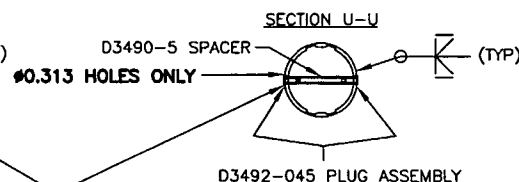
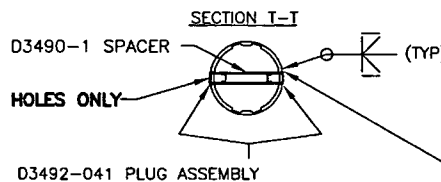
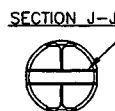
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D2750-043/-044 ASSEMBLY
D2750-043 SHOWN (D2750-044 OPPOSITE)

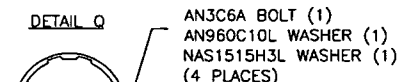
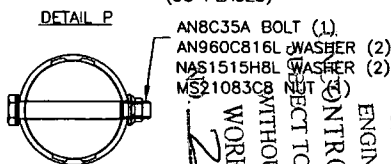
BOND D2739 WEB INTO D2750-3 (OR D2750-4)
OUTER TUBE WITH NON-STRUCTURAL
SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.



- WELDING INSTRUCTIONS**
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2743 SPACER
 3. WELD INTO PLACE
 4. GRIND FLUSH
 5. DRILL OUT SPACER TO Ø0.484
 6. SPOT FACE Ø0.750 (SECTION J-J ONLY)



- WELDING INSTRUCTIONS**
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
 3. WELD INTO PLACE
 4. GRIND FLUSH
 5. INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS



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